

Date: Thursday, 20/11/2008 3:30:25 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : HELI ACCESS STEP EXT HIGH GEAR
<b>Job Number</b> : 43580	
<b>Estimate Number</b> : 12874	
<b>P.O. Number</b> :	<b>Part Number</b> : D205633025
<b>This Issue</b> : 20/11/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : DSI 9300 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 40921	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 15/12/2008 <b>Qty:</b> 4 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JLD 08.11.21</u>	
<b>Comment</b> : Est Rev:B Added D3165-1 KJ/JLM 05-09-09	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy bluefile &amp; type labels per PPPD205-633-025

CHG001

2/15 09/01/06

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D2022101	Spacer
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**Comment:** Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Spacer

Batch:

B39880

4.0	D2022103	Spacer
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Spacer

Batch:

B38329

5.0	D2562005	Strut
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Strut

Batch:

35045

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 20/11/2008 3:30:25 PM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP EXT HIGH GEAR

Job Number: 43580

Part Number: D205633025

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D2563	Step Weldment Assembly
-----	-------	------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Step Weldment Assembly  
Batch: B43746

7.0	D31651	Support Arm
-----	--------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Support Arm  
Batch: 43761

8.0	D2565301	Strut
-----	----------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Strut  
Batch: 40680

9.0	D2565303	Strut
-----	----------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Strut  
Batch: 26640

10.0	D2565305	Strut
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Strut  
Batch: 40681

11.0	D2565307	Strut
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Strut  
Batch: B40682

12.0	D2565309	Strut
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Strut  
Batch: 24448

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP EXT HIGH GEAR

Job Number: 43580

Part Number: D205633025

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

D3437045

Aft Strut Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Aft Strut Assembly

Batch:

411932

SS 08/12/24 (X4)

14.0

AN45A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch:

M108672

SS 08/12/24 (X4)

15.0

AN46A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Bolt

Batch:

M108558

SS 08/12/24 (X4)

16.0

AN47A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch:

M108977

SS 08/12/24 (X4)

17.0

AN412A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch:

M109297

SS 08/12/24 (X4)

18.0

AN414A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch:

M107534

SS 08/12/24 (X4)

19.0

AN44 7A

EYEBOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

EYEBOLT

Batch:

M108638

\*\*\*\*\*ENSURE THIS IS AN44-7A EYEBOLT\*\*\*\*\*

SS 08/12/24 (X4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: HELI ACCESS STEP EXT HIGH GEAR

Job Number: 43580

Part Number: D205633025

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN514A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch:

M166166

SS 08/12/24 (x4)

21.0

AN960JD416

Washer



Comment: Qty.: 14.0000 Each(s)/Unit Total: 56.0000 Each(s)

Washer

Batch:

M109249

SS 08/12/24 (x4)

22.0

AN960JD516

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Washer

Batch:

M109752

SS 08/12/24 (x4)

23.0

MS21042L4

Nut



Comment: Qty.: 7.0000 Each(s)/Unit Total: 28.0000 Each(s)

Nut

Batch:

M108145

SS 08/12/24 (x4)

24.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Nut

Batch:

M109297

SS 08/12/24 (x4)

25.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

SS 09/01/06 (x4)

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205633-025

Location:

PPP Rev:

SS 09/01/06 (x4)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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Drawing Name: HELI ACCESS STEP EXT HIGH GEAR

Job Number: 43580

Part Number: D205633025

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

20/11/07

Job Completion



20.01.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector



Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN RF	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. DSI 9300	REV. B SHEET 1 OF 6
DATE 05.08.12		TITLE SIMPLEX TANK STEP	SCALE NTS
A	05.05.05	NEW ISSUE	
B	05.08.12	ADD STRUTS IF TANK REMOVED	

## DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D205-633 REV. A

REF. CANADIAN STC: SH96-57

REF. FAA STC: SR00592NY, SR00593NY, SR00594NY

THE PURPOSE OF THIS SERVICE INSTRUCTION IS TO ADD THE D205-633-021/-022/-023/-024/-025/-026 STEPS TO ADDRESS COMPATABILITY WITH THE SIMPLEX MODEL 304 FIRE ATTACK TANK. D205-633-021/-022 ARE IDENTICAL TO D205-633-011, EXCEPT AS SHOWN HERE. D205-633-023/-024 ARE IDENTICAL TO D205-633-013, EXCEPT AS SHOWN HERE. D205-633-025/-026 ARE IDENTICAL TO D205-633-015, EXCEPT AS SHOWN HERE.

NOTE THAT THE STRUTS REQUIRED TO INSTALL THE STEPS ON THE LOWER AFT HARDPOINT HAVE ALSO BEEN INCLUDED WITH THE KITS IN CASE THE TANK IS REMOVED FOR ANY REASON. THESE STRUTS SHOULD BE INSTALLED I.A.W. IIN-D205-633, EXCEPT REPLACE EYEBOLT WITH AN4 BOLT ON LOWER HARDPOINT. ALSO NOTE THAT IF THE THREADS PROTRUDE THROUGH THE BAR ON THE D3437-XXX STRUT ASSEMBLIES AFTER ADJUSTMENT THEY MAY BE TRIMMED OFF.

### WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-633-021 <i>HELI-ACCESS-STEP™</i>	14.0 lb 6.35 kg	-50.0 in -1.27 m	-700 in-lb -8.06 m kg	94.5 in 2.40 m	1323 in-lb 15.24 m kg
D205-633-022 <i>HELI-ACCESS-STEP™</i>	13.2 lb 6.00 kg	+50.0 in +1.27 m	+660 in-lb +7.62 m kg	94.5 in 2.40 m	1247 in-lb 14.40 m kg
D205-633-023 <i>HELI-ACCESS-STEP™</i>	14.3 lb 6.50 kg	-50.0 in -1.27 m	-715 in-lb -8.26 m kg	94.5 in 2.40 m	1351 in-lb 15.6 m kg
D205-633-024 <i>HELI-ACCESS-STEP™</i>	13.5 lb 6.14 kg	+50.0 in +1.27 m	+675 in-lb +7.80 m kg	94.5 in 2.40 m	1276 in-lb 14.74 m kg
D205-633-025 <i>HELI-ACCESS-STEP™</i>	14.6 lb 6.64 kg	-50.0 in -1.27 m	-730 in-lb -8.43 m kg	94.5 in 2.40 m	1380 in-lb 15.94 m kg
D205-633-026 <i>HELI-ACCESS-STEP™</i>	13.8 lb 6.27 kg	+50.0 in +1.27 m	+690 in-lb +7.96 m kg	94.5 in 2.40 m	1304 in-lb 15.05 m kg

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BRANCH  
DAO # 01-O-01

**APPROVED**



BY:   
D. SHEPHERD (DE # 02)

DATE: 05.08.12  
CERT. NO.: SH96-57  
ISSUE NO.: #5

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CHECKED 	APPROVED 	DRAWING NO. DSI 9300	REV. 8 SHEET 2 OF 6
DATE 05.08.12		TITLE SIMPLEX TANK STEP	SCALE NTS

**PARTS LIST**

QTY -021	QTY -022	QTY -023	QTY -024	QTY -025	QTY -026	Part Number	Description
X						D205-633-021	Heli-Access-Step™ (LH), High Gear
	X					D205-633-022	Heli-Access-Step™ (RH), High Gear
		X				D205-633-023	Heli-Access-Step™ (LH), Extended High Gear (31")
			X			D205-633-024	Heli-Access-Step™ (RH), Extended High Gear (31")
				X		D205-633-025	Heli-Access-Step™ (LH), Extended High Gear (39")
					X	D205-633-026	Heli-Access-Step™ (RH), Extended High Gear (39")
4	4	4	4	4	4	D2022-101	SPACER
2	2	2	2	2	2	D2022-103	SPACER
				1	1	D2562-005	STRUT
1	1					D2562-011	STRUT
		1	1			D2562-013	STRUT
1		1		1		D2563	WELDMENT ASSEMBLY
				*1	*1	D3165-1	STRUT
1	1					D2565-101	STRUT
1	1					D2565-103	STRUT
1	1					D2565-105	STRUT
1	1					D2565-107	STRUT
1	1					D2565-109	STRUT
*1	*1					D2565-111	STRUT
		1	1			D2565-201	STRUT
		1	1			D2565-203	STRUT
		1	1			D2565-205	STRUT
		1	1			D2565-207	STRUT
		1	1			D2565-209	STRUT
		*1	*1			D2565-211	STRUT
				1	1	D2565-301	STRUT
				1	1	D2565-303	STRUT
				1	1	D2565-305	STRUT
				1	1	D2565-307	STRUT
				1	1	D2565-309	STRUT
1	1					D3437-041	AFT STRUT ASSEMBLY
		1	1			D3437-043	AFT STRUT ASSEMBLY
				1	1	D3437-045	AFT STRUT ASSEMBLY
	1		1		1	D3438-042	WELDMENT ASSEMBLY
1	1	1	1	1	1	AN4-5A	BOLT
4	4	3	3	3	3	AN4-6A	BOLT
1	1	1	1	1	1	AN4-7A	BOLT
1	1					AN4-11A	BOLT
		1	1	1	1	AN4-12A	BOLT
1	1	1	1	1	1	AN4-14A	BOLT
1	1	1	1	1	1	AN44-7A	EYEBOLT
1	1	1	1	1	1	AN5-14A	BOLT
16	16	14	14	14	14	AN960JD416	WASHER
3	3	3	3	3	3	AN960JD516	WASHER
8	8	7	7	7	7	MS21042L4	NUT (or MS21042-4)
2	2	2	2	2	2	MS21042L5	NUT (or MS21042-5)

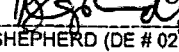
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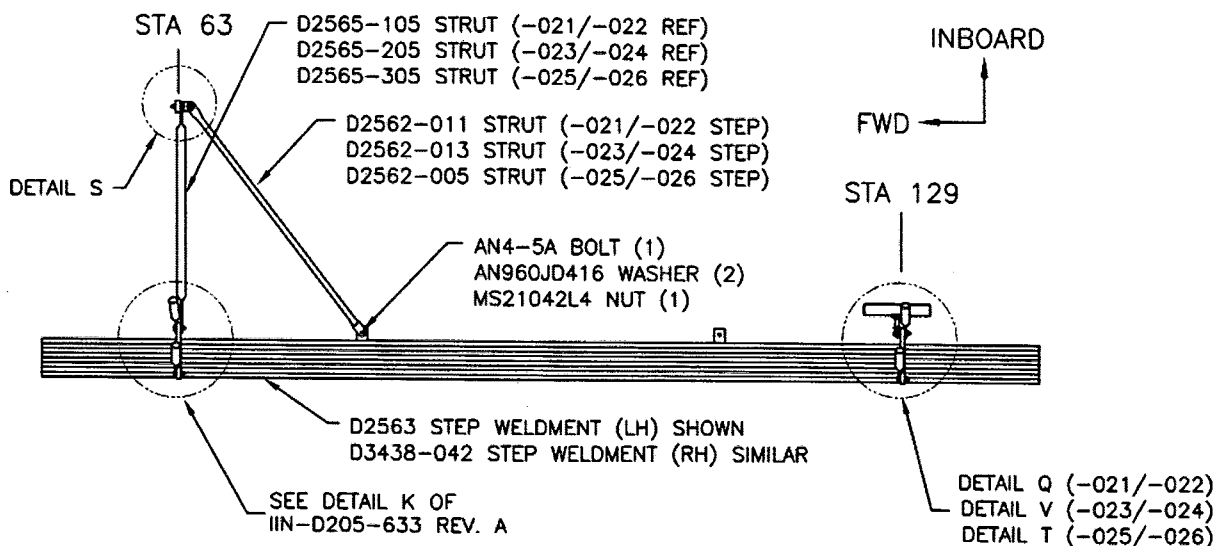
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9300	REV. B 3 OF 6
DATE 05.08.12	TITLE SIMPLEX TANK STEP KIT		SCALE NTS

**INSTALLATION OF D205-633-021/-022/-023/-024/-025/-026**

INSTALL D205-633-021/-022 AS PER THE D205-633-011 STEP OF INSTALLATION INSTRUCTIONS IIN-D205-633 REV.A, EXCEPT REPLACE D2565-111 STRUT WITH THE D3437-041 AFT STRUT ASS'Y, REMOVE D2562-001 STRUT, INSTALL D2562-011 STRUT AS SHOWN.

INSTALL D205-633-023/-024 AS PER THE D205-633-013 STEP OF INSTALLATION INSTRUCTIONS IIN-D205-633 REV.A, EXCEPT REPLACE D2565-211 STRUT WITH THE D3437-043 AFT STRUT ASS'Y, REMOVE D2562-003 STRUT, INSTALL D2562-013 STRUT AS SHOWN.

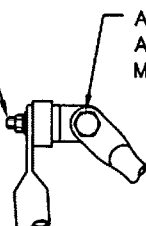
INSTALL D205-633-025/-026 AS PER THE D205-633-015 STEP OF INSTALLATION INSTRUCTIONS IIN-D205-633 REV.A, EXCEPT REPLACE D3165-1 SUPPORT ARM WITH THE D3437-045 AFT STRUT ASS'Y AS SHOWN.

**D205-633-021/-023/-025 SHOWN.****D205-633-022/-024/-026 SIMILAR**

(VIEW LOOKING DOWN)

AN44-7A EYEBOLT (1)  
AN960JD516 WASHER (1)  
MS21042L5 NUT (1)

**DETAIL S**  
NOT TO SCALE



AN4-6A BOLT (1)  
AN960JD416 WASHER (2)  
MS21042L4 NUT (1)

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BY: *[Signature]*  
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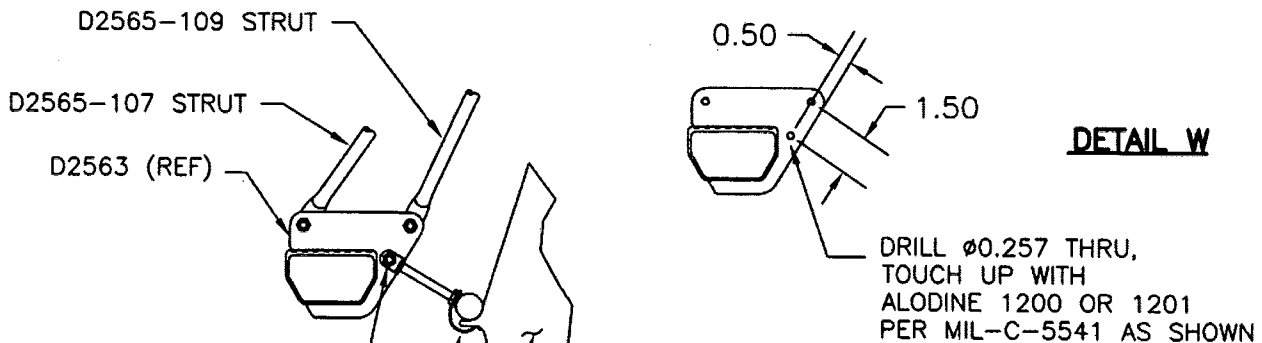
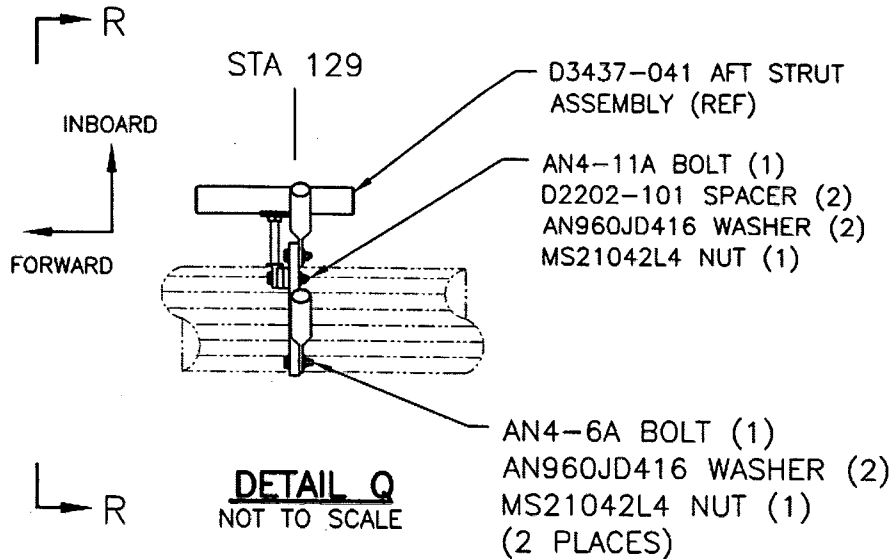
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9300	REV. B SHEET 4 OF 6
DATE 05.08.12	TITLE SIMPLEX TANK STEP		SCALE NTS



SEE DRILLING DETAIL W

D3437-041  
AFT STRUT ASSEMBLY (1)  
ADJUST LENGTH TO SUIT

SIMPLEX MODEL 304 FIRE  
ATTACK TANK (REF)

**(-021/-022 STEP)**

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BY: D. SHEPHERD (DE # 02)

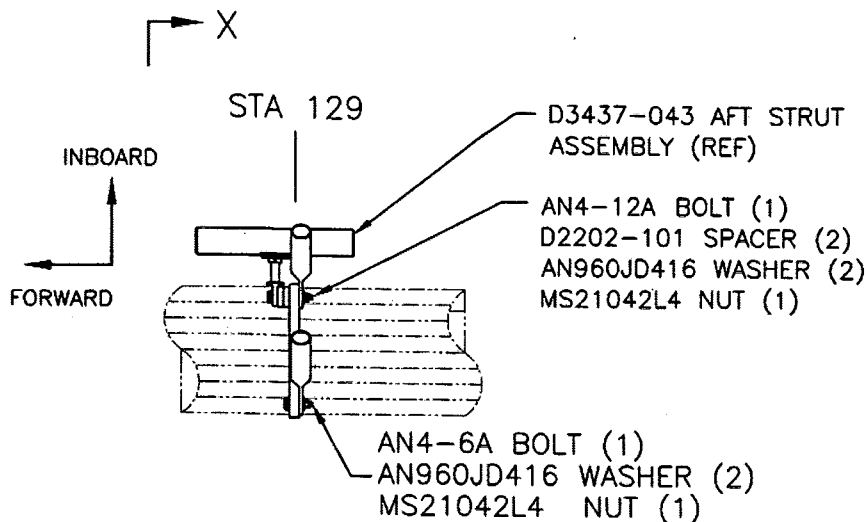
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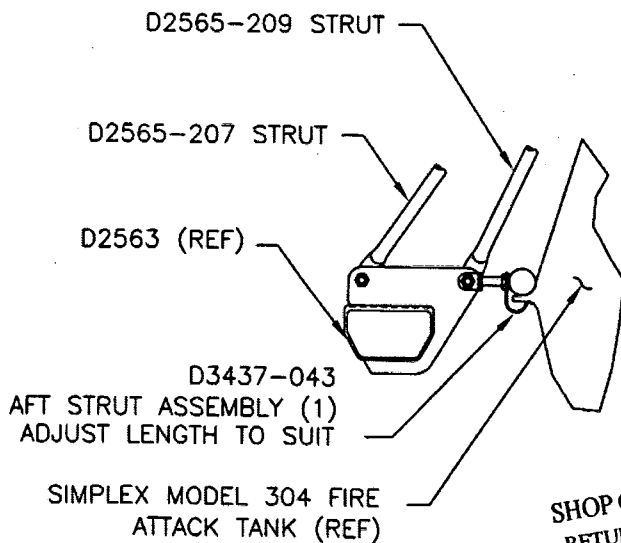
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DATE 05.08.12	TITLE SIMPLEX TANK STEP		SCALE NTS



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**(-023/-024 STEP)**

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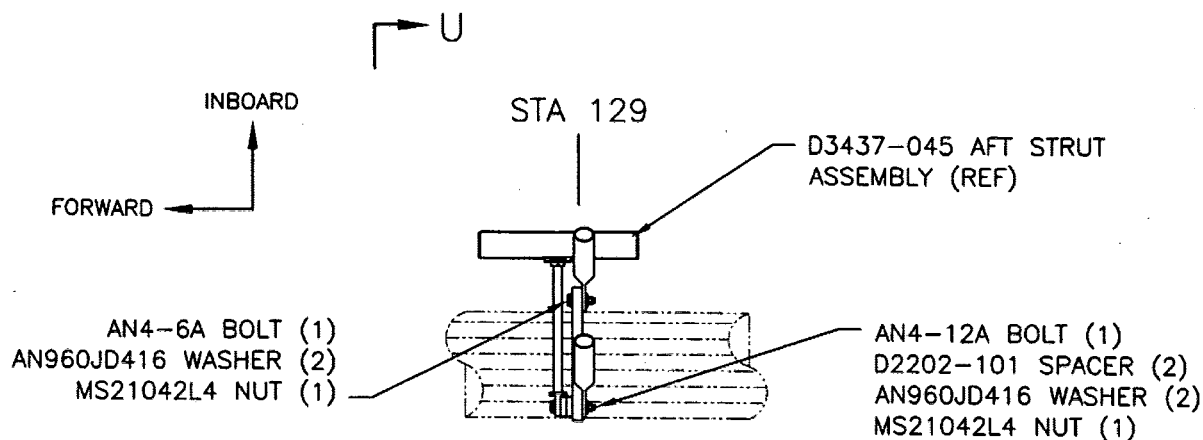
CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
<b>APPROVED</b> <i>[Signature]</i>	
BY:	D. SHEPHERD (DE # 02)
DATE:	05.08.12
CERT. NO.:	SH96-57
ISSUE NO.:	#5

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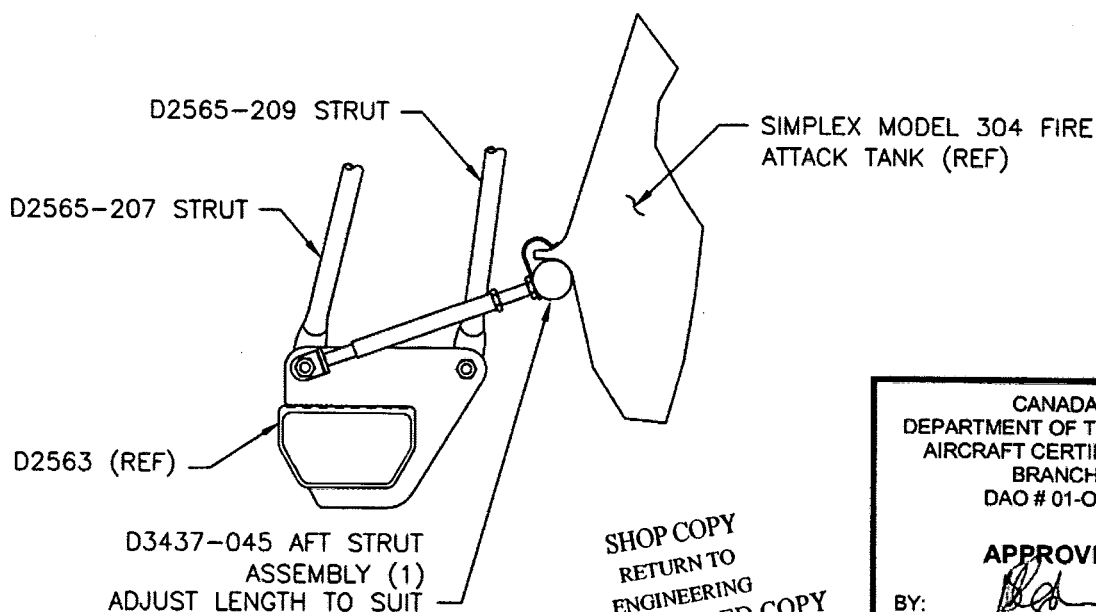
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**DART**

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9300	REV. B SHEET 6 OF 6
DATE 05.08.12	TITLE SIMPLEX TANK STEP		SCALE NTS



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CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

**APPROVED**

BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 05.08.12  
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Date: Friday, 21/11/2008 4:31:05 PM  
User: Julie Dawson

## Process Sheet

451

**Customer** : CU-DAR001 Dart Helicopters Services  
**Job Number** : 43580  
**Estimate Number** : 12874  
**P.O. Number** :  
**This Issue** : 21/11/2008 **S.O. No.** :  
**Prsht Rev.** : NC  
**First Issue** : 20/11/2008 **Type** : LARGE FAB ASSY  
**Previous Run** : 40921  
**Written By** :  
**Checked & Approved By** :  
**Comment** : Est Rev:B Added D3165-1 KJ/JLM 05-09-09

**Drawing Name** : HELI ACCESS STEP EXT HIGH GEAR  
**Part Number** : D205633025  
**Drawing Number** : DSI 9300 REV B  
**Project Number** : N/A  
**Drawing Revision** : B  
**Material** :  
**Due Date** : 15/12/2008 **Qty:** 4 **Um:** Each

## Additional Product

Job Number:



**Seq. #:** **Machine Or Operation:** **Description :**

1.0 DC DOCUMENT CONTROL



JLD 08.12.03

**Comment:** DOCUMENT CONTROL

Photocopy bluefile &amp; type labels per PPPD205-633-025 CHG001

2.0 PACKAGING 1 PACKAGING RESOURCE #1

**Comment:** PACKAGING RESOURCE #1

Pick Packing Kit

3.0 D2022101 Spacer

**Comment:** Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Spacer

Batch: \_\_\_\_\_

Job Completion

